

Date: Monday, 1/8/2007 10:44:28 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 30141	
Estimate Number : 10330	
P.O. Number : N/A	Part Number : D2746
This Issue : 1/8/2007 S.O. No. : N/A	Drawing Number : D2746 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 29012	Material : N/A
Written By : <u> </u>	Due Date : 1/30/2007 Qty: 50 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev: D 02.10.24 Re-format KJ	
Est Rev: E 06-03-21 as Per Rev C JLM	
Est Rev: F 06-06-12 Now On Waterjet JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2746

Dwg Rev: CProg Rev: C

ml 07 03 22

2-Deburr if necessary

2.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.4263 sf(s)/Unit Total: 21.3150 sf(s)

1010/1025/A21/6aA .040" SHEET

(M1010S20GA)

Batch: M103840

ml 07 03 22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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ml 07 03 22

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/29

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/29	5	1 part missing count 49		?				

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 30141

Part Number: D2746

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D2746 using Jigs DT8261 and DT8326

2-Form joggle on Punch as per Dwg D2746 using Jig DT8158 Identify as D2746

SB

07/03/27

MF

07-03-27

49
49

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-03-28 (49)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FL

07/03/28

(49)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

07/03/28

(49)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FINISHING

MS

07-03-28

49

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/29

(49)

Job Completion



07-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

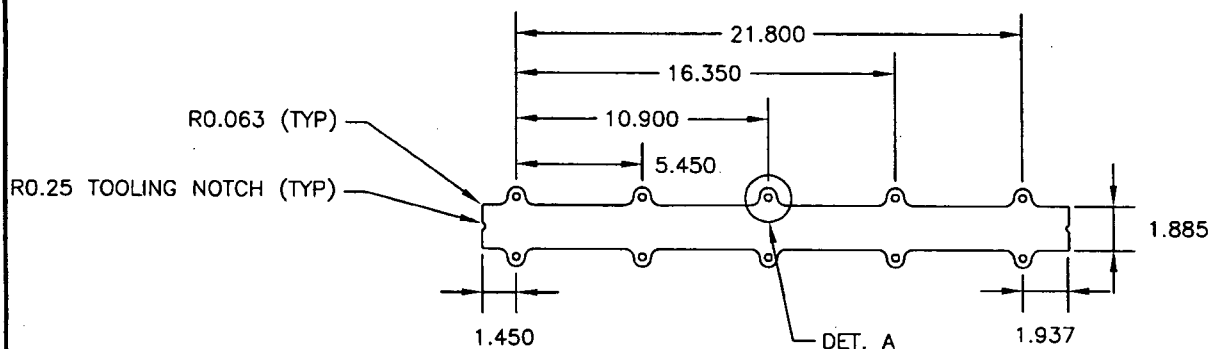
NOTE: Date & initial all entries

DART

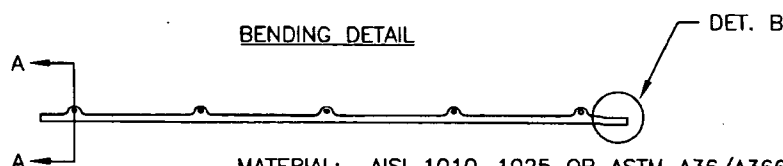
RELEASED
06-02-07

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
F11	F11	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. C	
		D2746	SHEET 1 OF 1	
DATE		TITLE	SCALE	
06.01.12		WEARSHOE	1:8	
A	98.04.16	NEW ISSUE		
B	98.08.18	RE-DESIGN		
C	06.01.12	ENLARGE HOLES TO IMPROVE FIT		

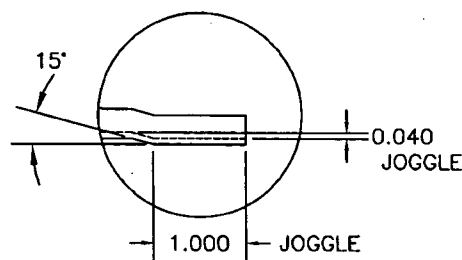
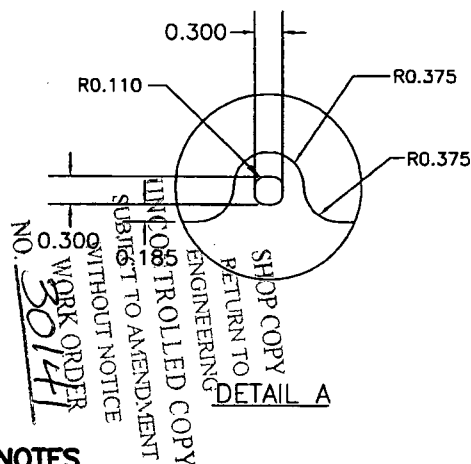
FLAT PATTERN



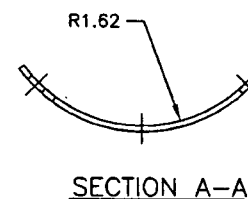
BENDING DETAIL



MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)



DETAIL B



SECTION A-A

NOTES

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 20 GAUGE (0.040 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) THIS PART CAN BE MADE BY MODIFYING D2656-21